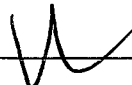
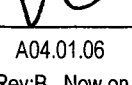


A.S.A.P

Dart Aerospace Ltd.

Date: Monday, 11/27/2006 8:36:20 AM  
User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEBBING TIDY
Job Number	: 29694		
Estimate Number	: 11381		
P.O. Number	: N/A	Part Number	: D32153
This Issue	: 11/27/2006 S.O. No. : N/A	Drawing Number	: D3215 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 29139	Material	: N/A
Written By	: 	Due Date	: 11/30/2006
Checked & Approved By	: 	Qty:	8 Um: Each
Comment	: Est. A04.01.06 New issue KJ/RF Est Rev:B Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total : 0.2167 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Identify for D3215-3A

Batch: M102723 MA 06 11 27 (8)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3215

Dwg Rev: CProg Rev: C MA 06 11 27 (8)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK MA 06 11 27 (8)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/27/2006 8:36:20 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 29694

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: .0084 sf(s)/Unit Total : 0.0672 sf(s)

5052-H32 .040 Sheet

Batch: m 102448

*ml*

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut blank: 2.130" x 0.530"

2-Deburr

*ml 06/11/29*

8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

*SB 06/11/29*

8

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06/11/29 (8)*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

A/R AL ROD BATCH: m102421

Identify as D3215-3

Grind flush

*CPC 06-11-29*

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*06/11/29 (8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/11/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/27/2006 8:36:20 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 29694

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*MOC 11/28 (8)*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Ylam 06/11/29*

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*a.m 06/11/30 (8x)*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*CL 06/11/30 (8)*

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*CL 06/11/30 (8)*

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*CL 06/11/30 (8)*

Job Completion



*CL 06/11/30*

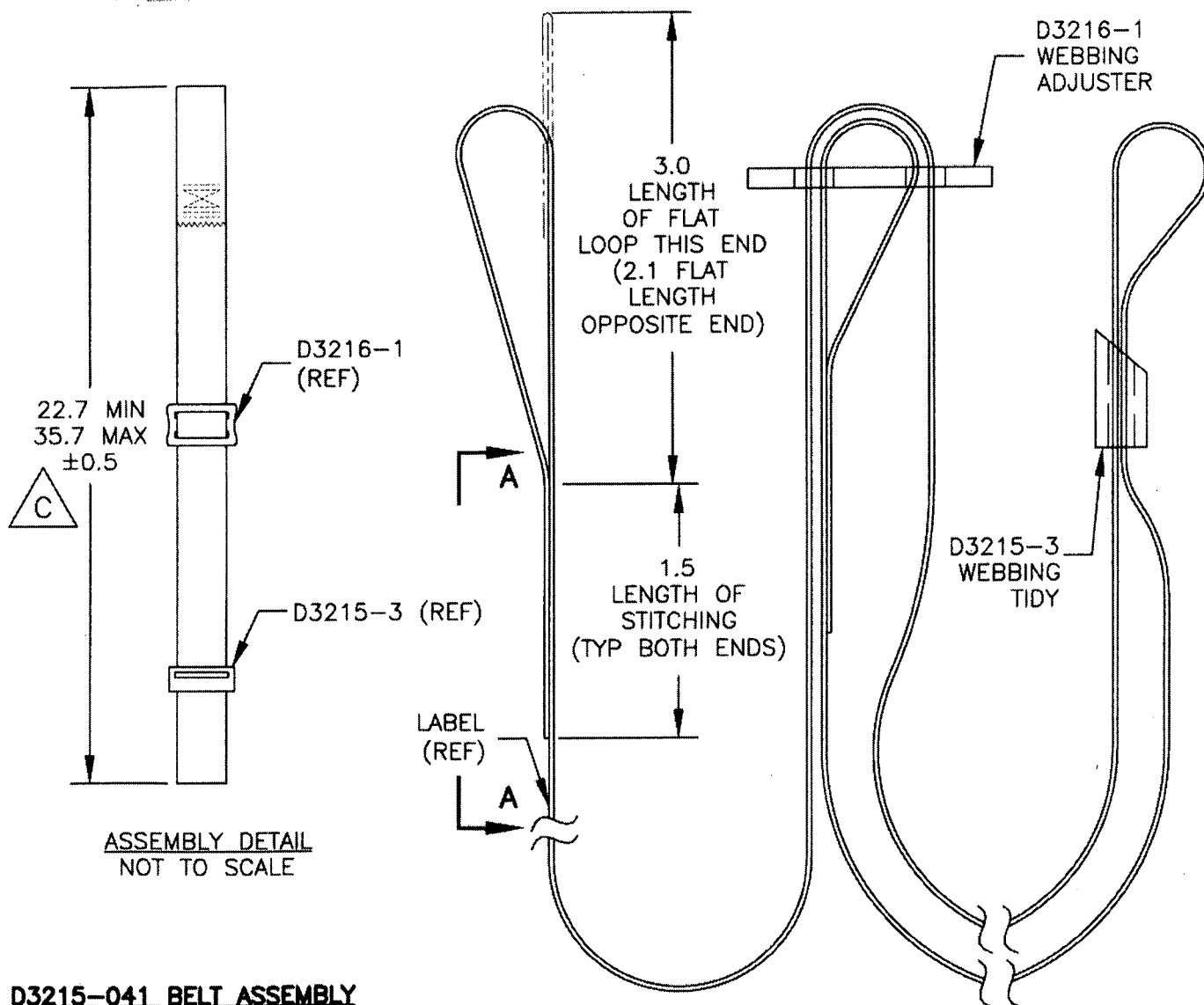
REFERENCE ONLY

**DART**



DESIGN	<i>ap</i>	DRAWN BY	<i>ap</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3215 REV. C SHEET 1 OF 3
DATE	04.03.05	TITLE	BELT ASSEMBLY	SCALE NTS
A	03.09.19	NEW ISSUE		
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE		
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING		

RELEASED  
04 03 05



**D3215-041 BELT ASSEMBLY**

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472  
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)  
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD  
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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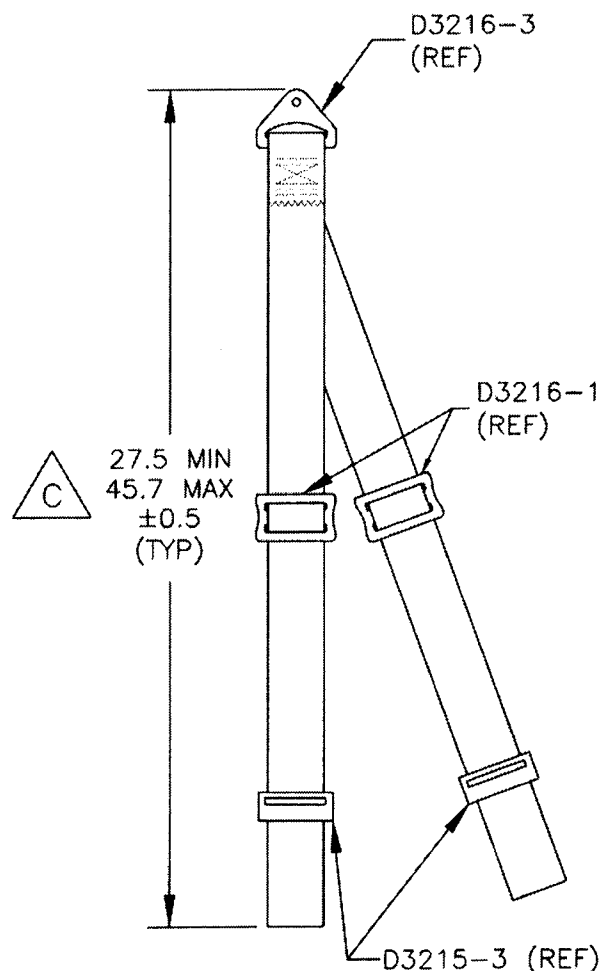
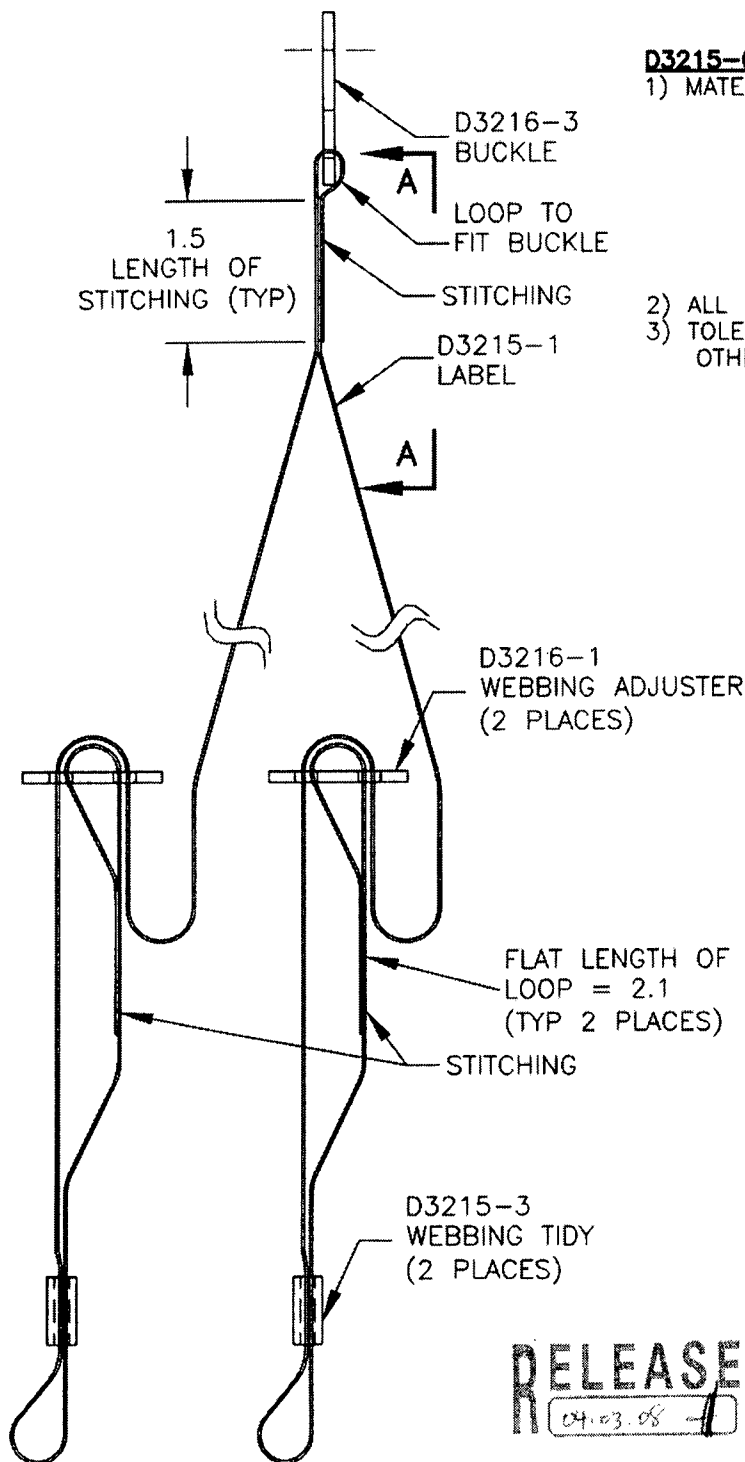
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05		TITLE BELT ASSEMBLY	SCALE NTS

### D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472  
(2" WIDE x 0.060" THICK  
BLACK POLYESTER WEBBING,  
CERTIFIED TO FAR 29.853A3,  
TENSILE STRENGTH 5700 lb MIN)  
THREAD = VT 295 TYPE II CLASS A SIZE 3,  
BLACK NYLON THREAD  
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED.



RELEASED  
04.03.05

ASSEMBLY DETAIL  
NOT TO SCALE

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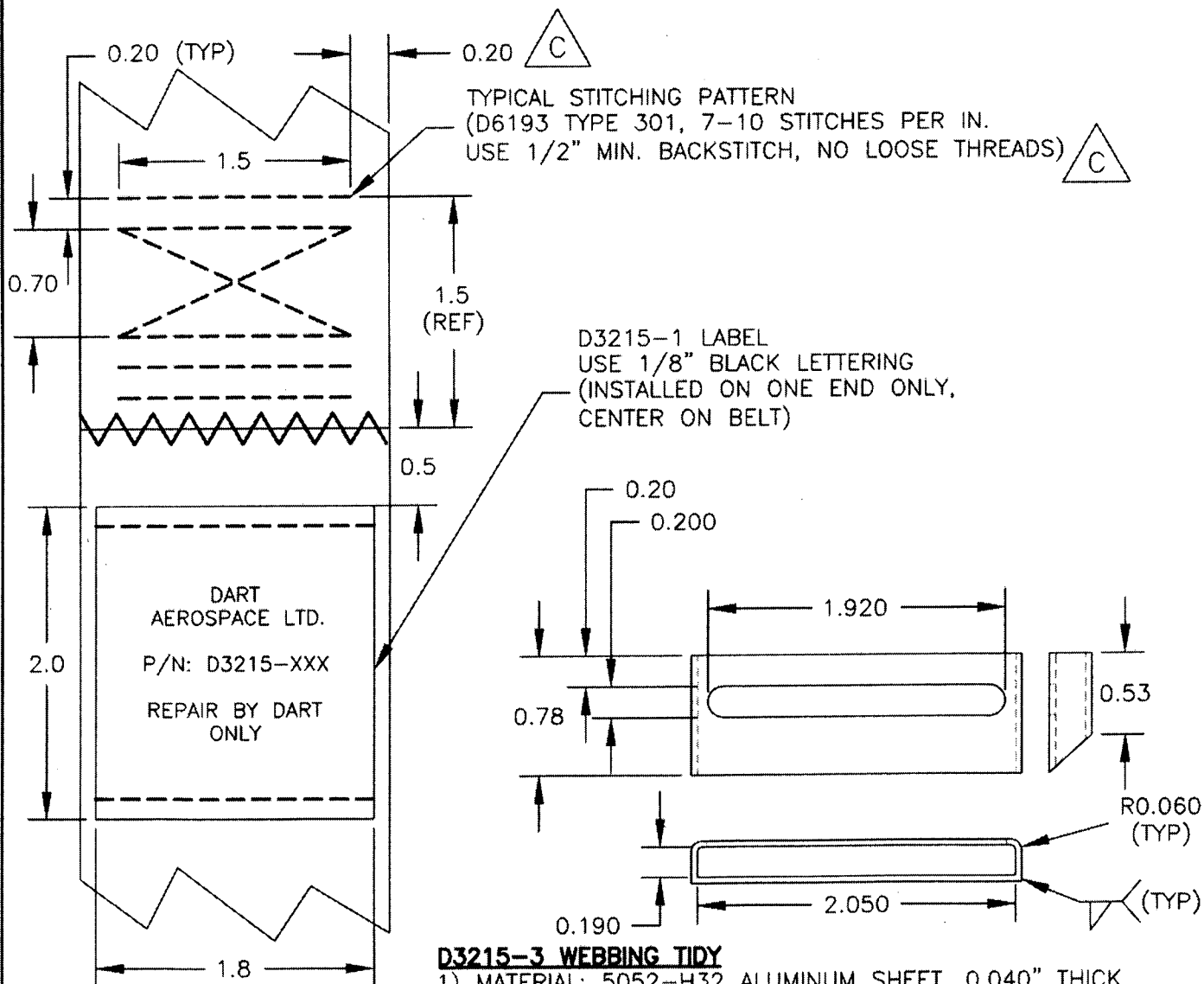
REFERENCE ONLY



DESIGN 40	DRAWN BY 40	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05	TITLE HARNESS ASSEMBLY		SCALE 1:1

### VIEW A-A

XXX = 041 FOR D3215-041  
XXX = 043 FOR D3215-043



### D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK  
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER  
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
NOTED

RELEASED  
04.03.05

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